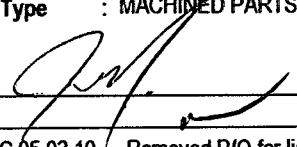


Date: Tuesday, 8/22/2006 9:59:58 AM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FUEL PURGE CANISTER
Job Number	: 28225B		
Estimate Number	: 10442		
P.O. Number	:	Part Number	: D32623
This Issue	: 8/22/2006 S.O. No. :	Drawing Number	: D3262 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 8/17/2006 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 26761B	Material	:
Written By	: 	Due Date	: 9/10/2006 Qty: 16 Um: Each
Checked & Approved By	:		
Comment	: Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
-----	--------------------	-------------------------



Comment: Qty.: 0.9668 f(s)/Unit Total : 15.4694 f(s)
Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick
(M6061T6B0.500x06.000)
Identify for D3262-3
Batch: M101422

2.79

ml 06/08/21 4464 16

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
Cut blanks: 6.000" x 0.500" x 5.400" long Bar

ml 06/08/21 16

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
Machine as per Folio FA457 and Dwg D3262
Identify for D3262-3
Deburr

J.F. / ml 06/08/22 16

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / ml 06/08/22 16

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SD 06-08-22 16

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 28225B

Part Number: D32623

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SH18

Sh 06/02/22

(16)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/28

(16)

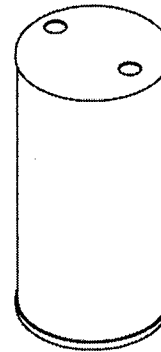
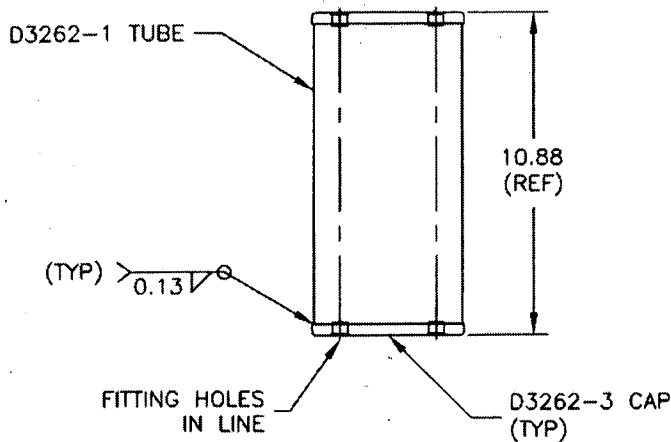
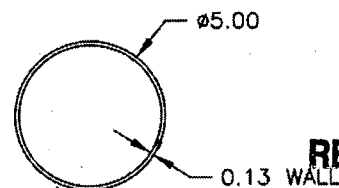
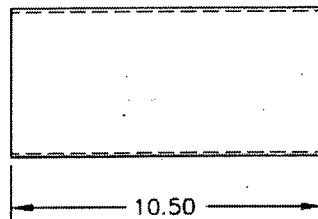
Job Completion



u 06/08/28

DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3262	REV. B SHEET 1 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	
B	05.02.14	ADD PRESSURE TESTING OPTION	

RELEASED
05.02.14**D3262-041 CANISTER ASSEMBLY****1 D3262-1 TUBE****D3262-041:**

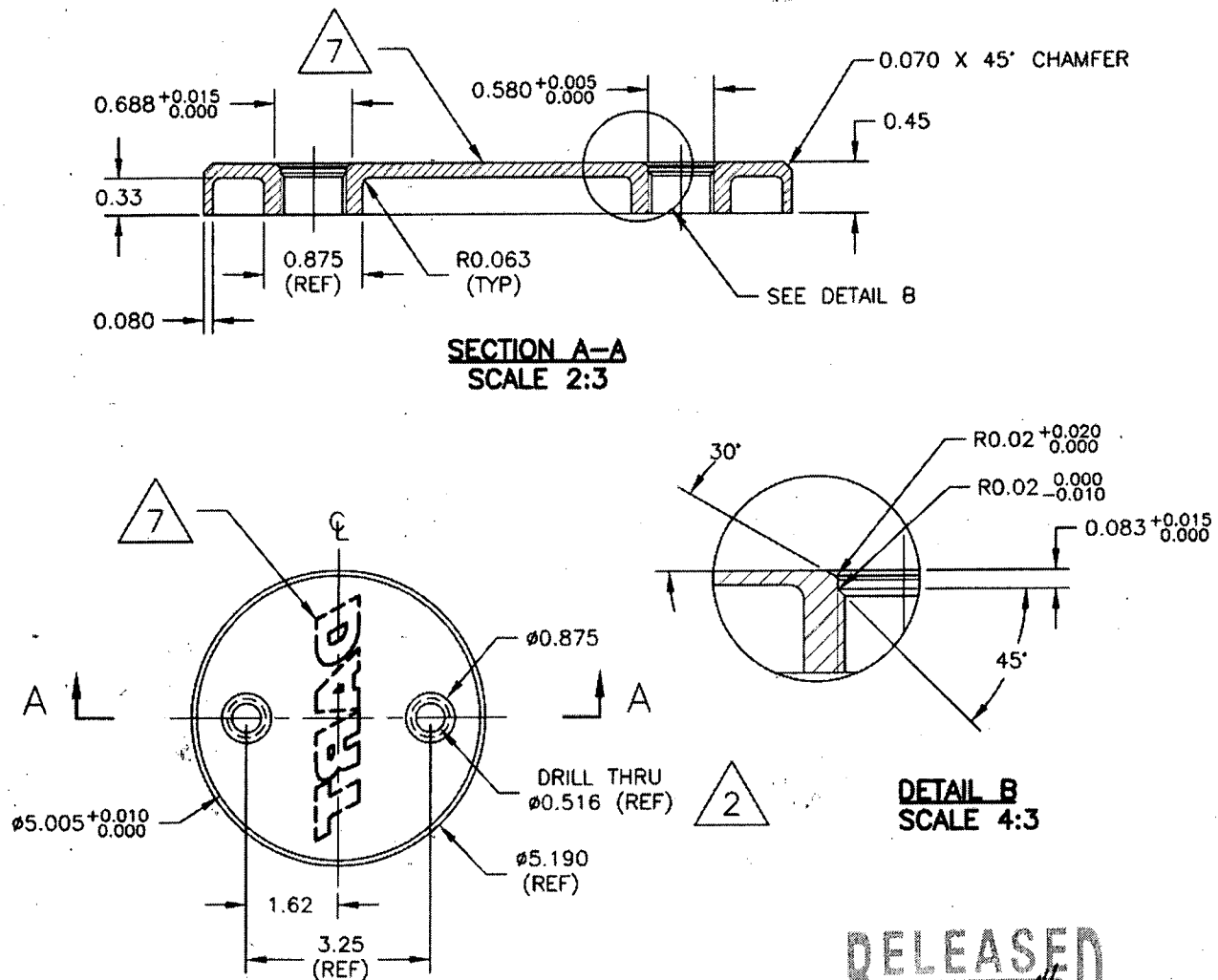
- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi
AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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DART

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3262	REV. B SHEET 2 OF 2
DATE 05.02.14		TITLE FUEL PURGE CANISTER	SCALE 1:3

**D3262-3 CAP****D3262-3**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH X 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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DART AEROSPACE LTD		Work Order: 28725B
Description: Cap		Part Number: D3262-3
Inspection Dwg: D3262	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	0.067 x 45°	✓			
0.45	+/-0.030	0.440	✓			
R0.063	+/-0.010	R0.063	✓			
0.090	+/-0.010	0.087	✓			
0.33	+/-0.030	0.335	✓			
5.005	+0.010/-0.000	5.000	✓			
0.688	+0.015/-0.000	0.688	✓			
3.250	+/-0.005	3.252	✓			
0.875	+/-0.010	0.870	✓			
Ø0.516	+0.005/-0.000	Ø0.518	✓			
Ø5.190	+/-0.010	Ø5.188	✓			
0.083	+0.015/-0.000	0.090	✓			
Ø0.580	+0.005/-0.000	Ø0.581	✓			
Ø5.005	+0.010/-0.000	Ø5.010	✓			

Measured by: <i>mf</i>	Audited by: <i>J.L</i>	Prototype Approval:	N/A
Date: 06/08/21	Date: 06/08/21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue P/O D3262-041	KJ/JLM	
B	05.04.28	Dimensions and tolerances revised	KJ/JLM	